



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-200
Job Sheet 179644



Part No: SWA25A-200

Job Qty: 7 ea

Part Name: Upper End Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA25A-200 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	7 Ea		7/6/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	7 pcs		7/6/18	0.00	7.00	MORI NLX		
120	QC	7 pcs		7/6/18	0.00	0.00	QC2		
130	QC	7 pcs		7/6/18	0.00	0.00	QC8		
140	Packaging	7 pcs		7/6/18	0.00	0.00	Packaging3		
150	QC21-SA	7 Ea		7/6/18	0.00	0.00	QC21		

Part Op 110 - Cut Blanks AT 7.00" 1-Machine as per DWG. FC144 FOLIO REV: AA DWG REV: 6.00
Descriptions: 2-Deburr ***Machine engrave up arrow*** 3-***Please see PEC to change engraving batch # for every w/o**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.500	17-4 SS H1150 Round Bar 3.500"	4.0810 ft (.583 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R3.500	4	5	0

Part Specifications

Specifications could not be found.



Container No: S085105



Part: SWA25A-200

Job No: 179644

Serial No/Batch: S085105

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/20/18 1:41 PM Dart.lajeunesse.marie

18-06-28 @ 11:00

Date: 06/28/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

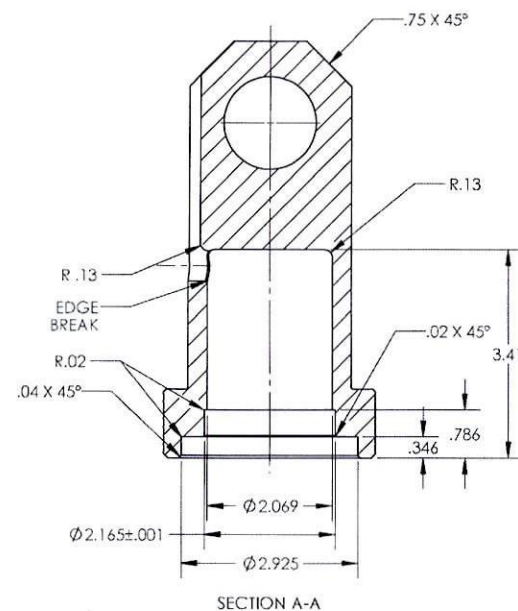
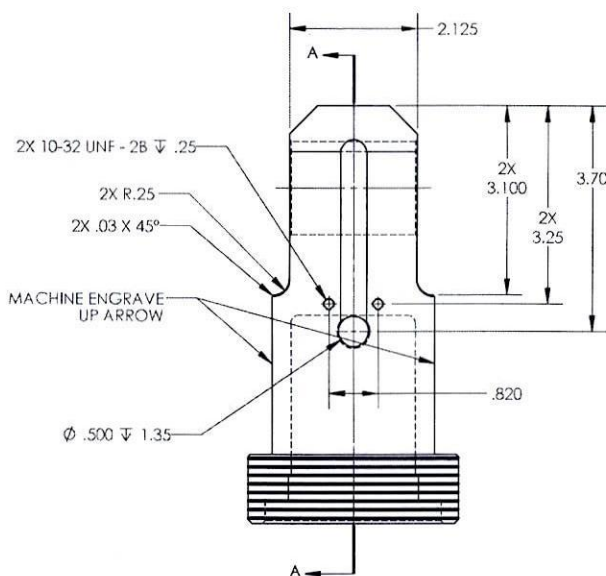
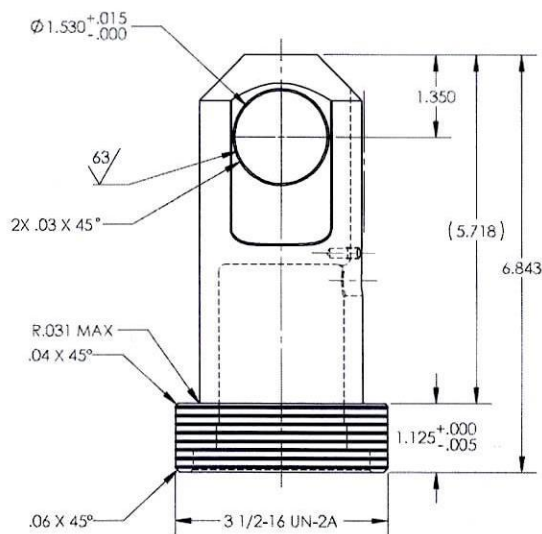
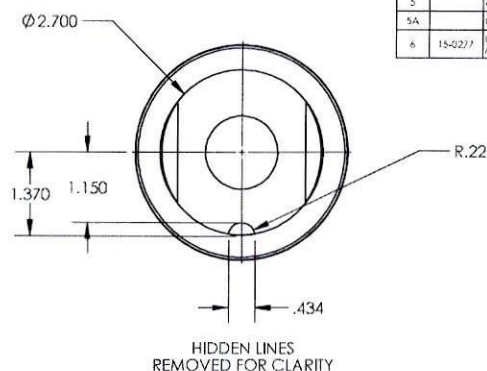
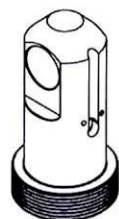
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
5		AS DRAWN BY CANAM	11/12/2012	JAG
5A		CHD B/O INFO TO BLANK	4/29/2014	JAG
6	15-0227	UPDATED TO NEW DRAFTING STANDARDS. ADDED UP-ARROW NOTE. ADDED MTL OPTION H1075. ADDED DIMS FROM SWA10A-200 BLANK DWG.	9/22/2015	DPD



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA25A-200	1	UPPER END SWIVEL	SS 17-4, H1150/H1075	

DART AEROSPACE	
TITLE UPPER END SWIVEL	
DWG NO. SWA25A-200	REV 6
MAT'L SS 17-4, H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ±.005 .XX ±.01 .X ±.1	APPROVED <i>D. Wood</i> REAT DEAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:2	DATE 2/22/2002
SHEET 1 OF 1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART AEROSPACE LTD		Work Order:	1796544
Description: Upper end Swivel		Part Number:	SWA25A-200
Inspection Dwg: SWA 25A-200		Rev: 6	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	+0.015 / -0.000	1.533			Vern LPO9	
.03 x 45°	±.01 x .5°	.032 x 45°			↓	
R.031	+0.000 / -0.005	.031			↓	
.04 x 45°	±.01 x .5°	.04 x 45°			↓	
3 1/2 -16 UN-2A						
Mat Ø 3.4936	±.0047	3.494			Mic 104.137	
Wire Ø .040					↓	
DOW 3.5207	±.0029	3.523			↓	
1.125	+0.000 / -0.005	1.122			Mic LPO2	
6.843	±.005	6.840			HG	
1.350	±.005	1.3515			↓	
Ø2.700	±.005	2.700			Mic LPO3	
1.370	±.005	1.370			Vern LPO9	
1.150	±.005	1.150			↓	
.434	±.005	.438			↓	
R.22	±.01	.219			↓	
10-32 UNF-2B	GO - NO GO	GO			↓	
.25	±.01	.25			↓	
R.25	±.01	.250			Rad gage	
Ø.500	±.005	.500			Vern LPO9	
1.35	±.01	1.360			↓	
.820	±.005	.822			↓	
3.70	±.01	3.701			HG	
3.25	±.01	3.250			↓	
3.100	±.005	3.101			↓	
2.125	±.005	2.127			Vern LPO9	
.75 x 45°	±.01 x .5°	.755 x 45°				
R.13	±.01	.125			Rad gage	
.04 x 45°	±.01 x .5°	.035 x 45°				

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18-06-18	Date:	18/07/04	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

SWA 25A-200

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	